

Date: Thursday, 12/14/2006 3:46:27 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 29978D		Part Number	: D30657		
Estimate Number	: 10380		Drawing Number	: D3065 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/14/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/12/2007		
Previous Run	: 28939D		Qty:	60	Um:	Each
Written By	: <u>JL 06/12/15</u>					
Checked & Approved By						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM					
Additional Product						
Job Number:						
Seq. #:	Machine Or Operation:	Description :				
1.0	M2024T3S040	2024-T3 .040 sheet 				
Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>M1024/48</u> X <u>06/12/21</u> <u>ML 06/12/19</u> (60)						
2.0	WATER JET	FLOW WATER JET 				
Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: <u>B</u> <u>M 06/12/21</u> (60) Prog. Rev: <u>B</u> <u>M 06/12/19</u> (60)						
2-Deburr if necessary <u>SAD</u> <u>06/12/23</u> (60)						
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 				
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>M 06/12/21</u> <u>M 06/12/19</u> (60) <u>PTO</u>						
4.0	QC8	SECOND CHECK 				
Comment: SECOND CHECK <u>M 06/12/22</u> (60)						
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 				
Comment: SMALL & MEDIUM FAB RESOURCE 1 <u>SAD</u> <u>06/12/23</u> (60)						
Deburr if necessary.						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3465-7 PAR #: N/A Fault Category: Prod/Fab. Ass' <sup>Prod/Assnall</sup> NCR:  Yes No DQA: AS Date: 07/02/13  
 QA: N/C Closed: AS Date: 07.02.14

NCR: <u>099780</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/12/20</u>	<u>3.0</u>	All parts are scrap do to wrong thickness of material <u>(Qty 60)</u>	<u>AS/02.12</u>	destroy & replace Make sure its the right thickness .040"	<u>AS</u> <u>06/12/20</u>	<u>AS</u> <u>06/12/20</u>	<u>AS</u> <u>06/12/20</u>	<u>AS</u> <u>06/12/20</u>

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 3:46:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 29978D

Part Number: D30657

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 07/02/06

60

7.0 QC5

INSPECT WORK TO CURRENT STEP



202.02.06 (60)



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AS/4L

07/02/06

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

PC 7/2/06 (60)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP 04/02/07 (60) PW

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/13

Job Completion



U 07/02/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29978D
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065	Rev: B	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

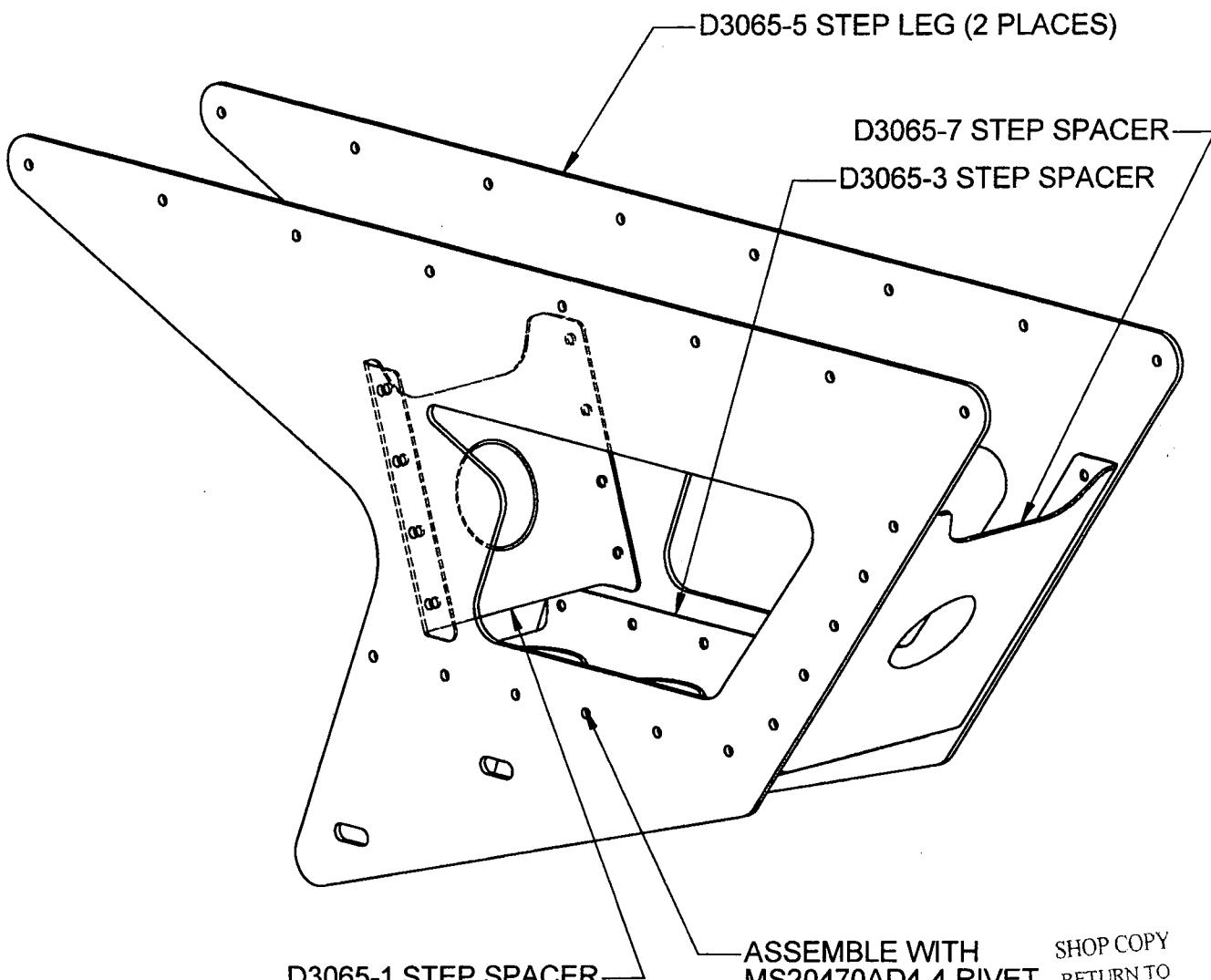
## X First Article      Prototype

Measured by:	<i>M. M.</i>	Audited by:		Prototype Approval:	N/A
Date:	<i>08/12/19</i>	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

**RELEASED***06.06.20***D3065-041 STEP LEG ASSEMBLY**

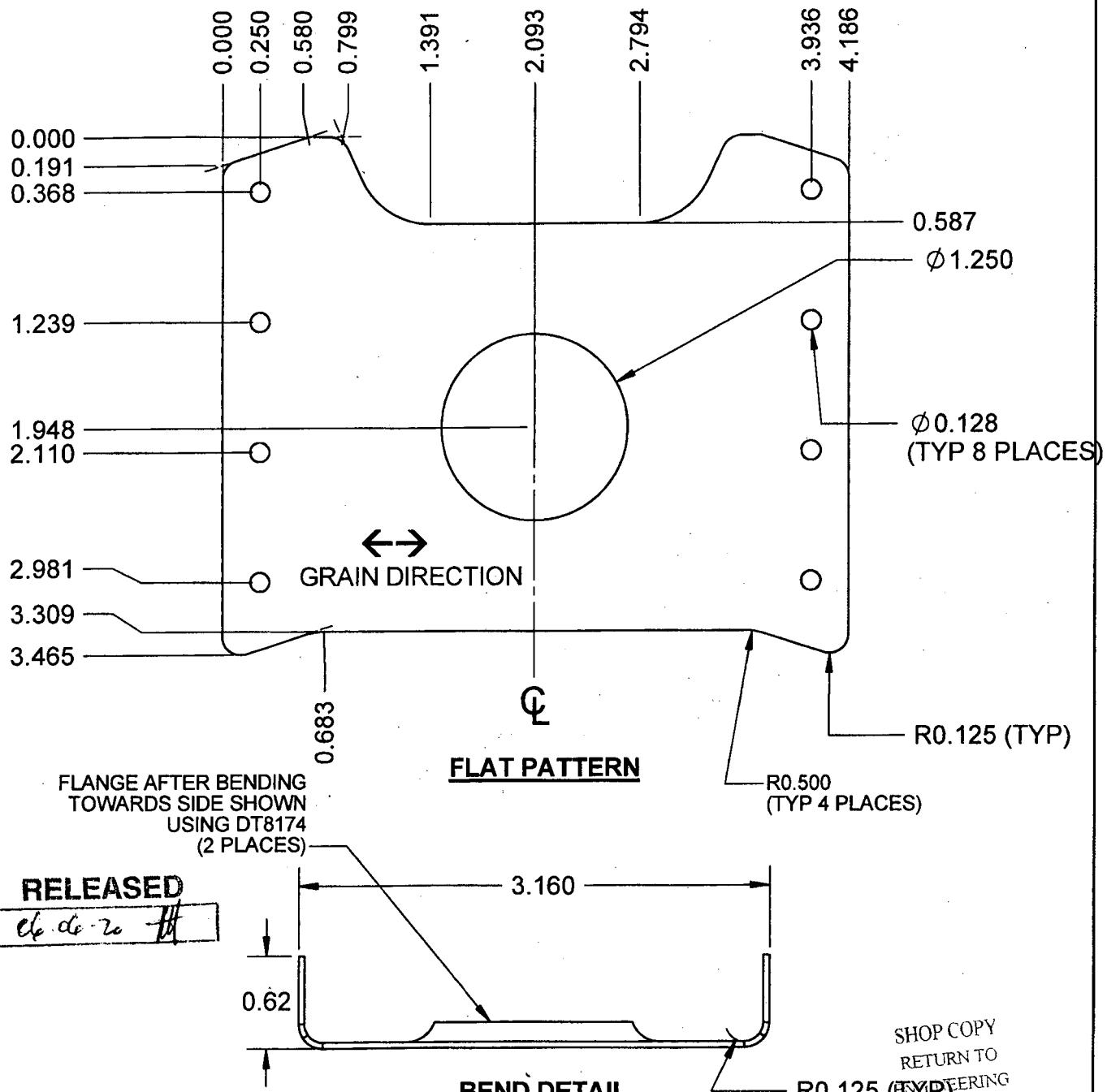
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WORK ORDER  
NO. *29978D*

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DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

**D3065-1 STEP SPACER**

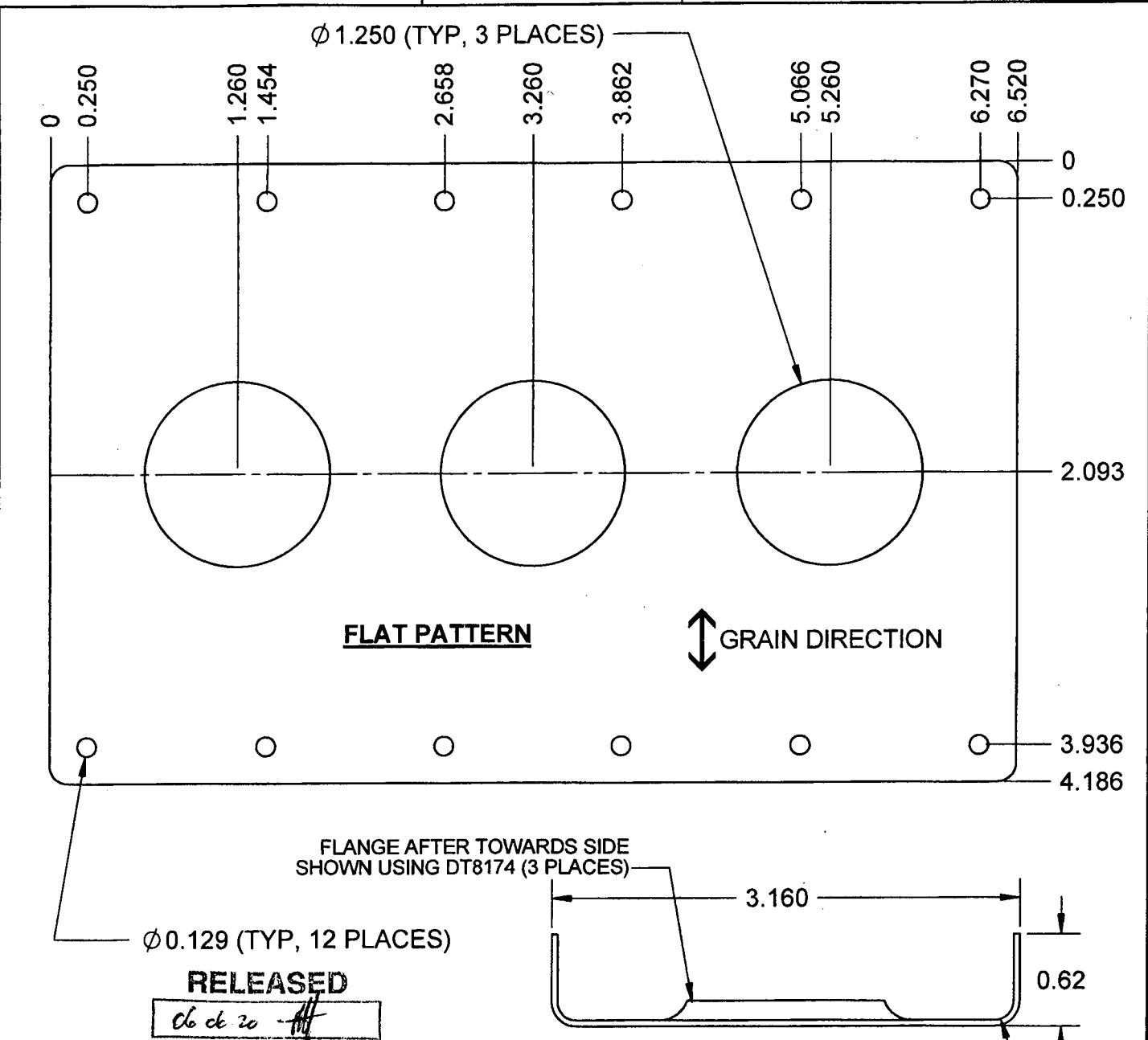
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D3065</b>	REV. B	SHEET 3 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1	



## **D3065-3 STEP SPACER**

1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040) R

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) PART IS SYMMETRIC ABOUT CENTERLINE

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

## **BEND DETAIL**

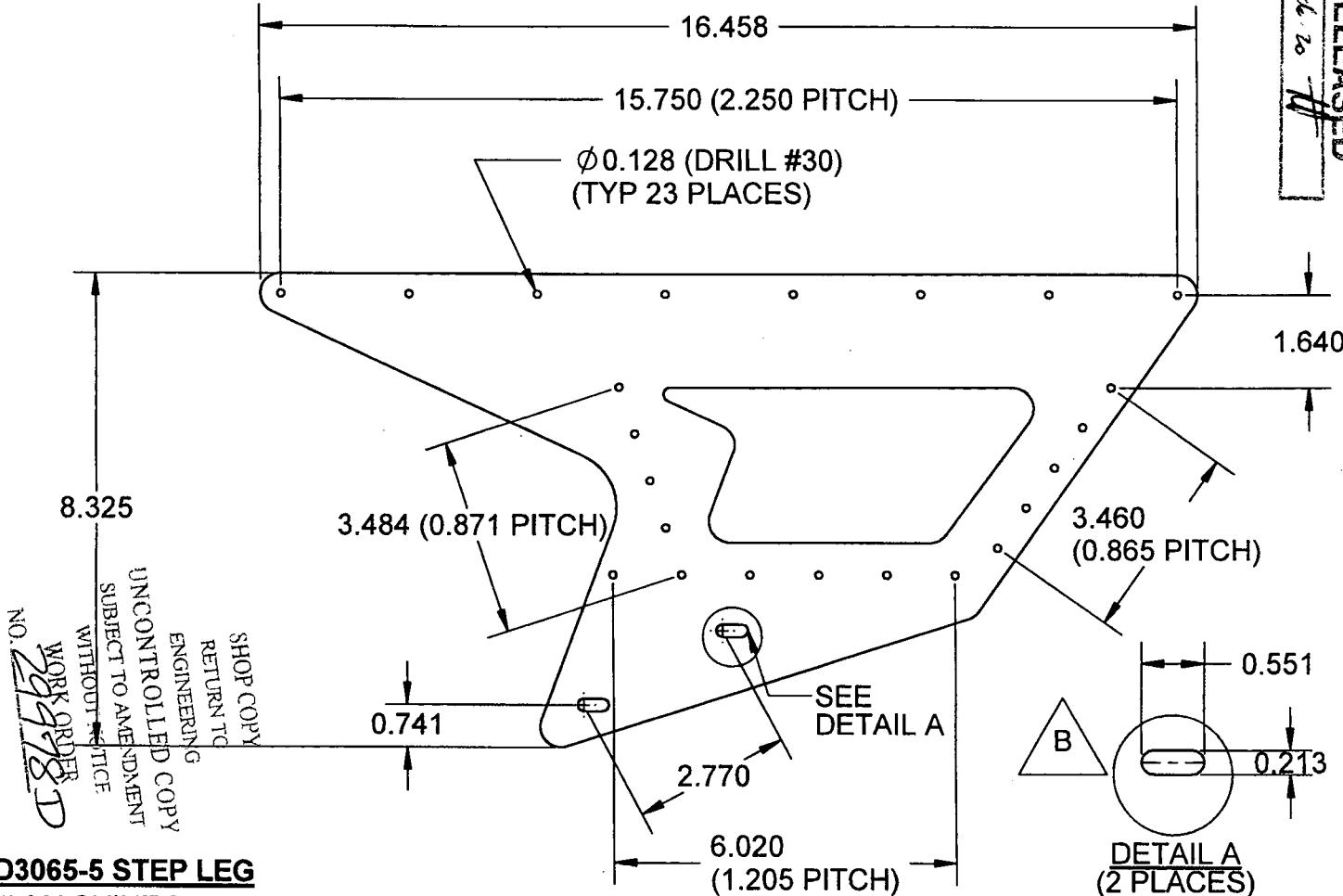
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**DART**

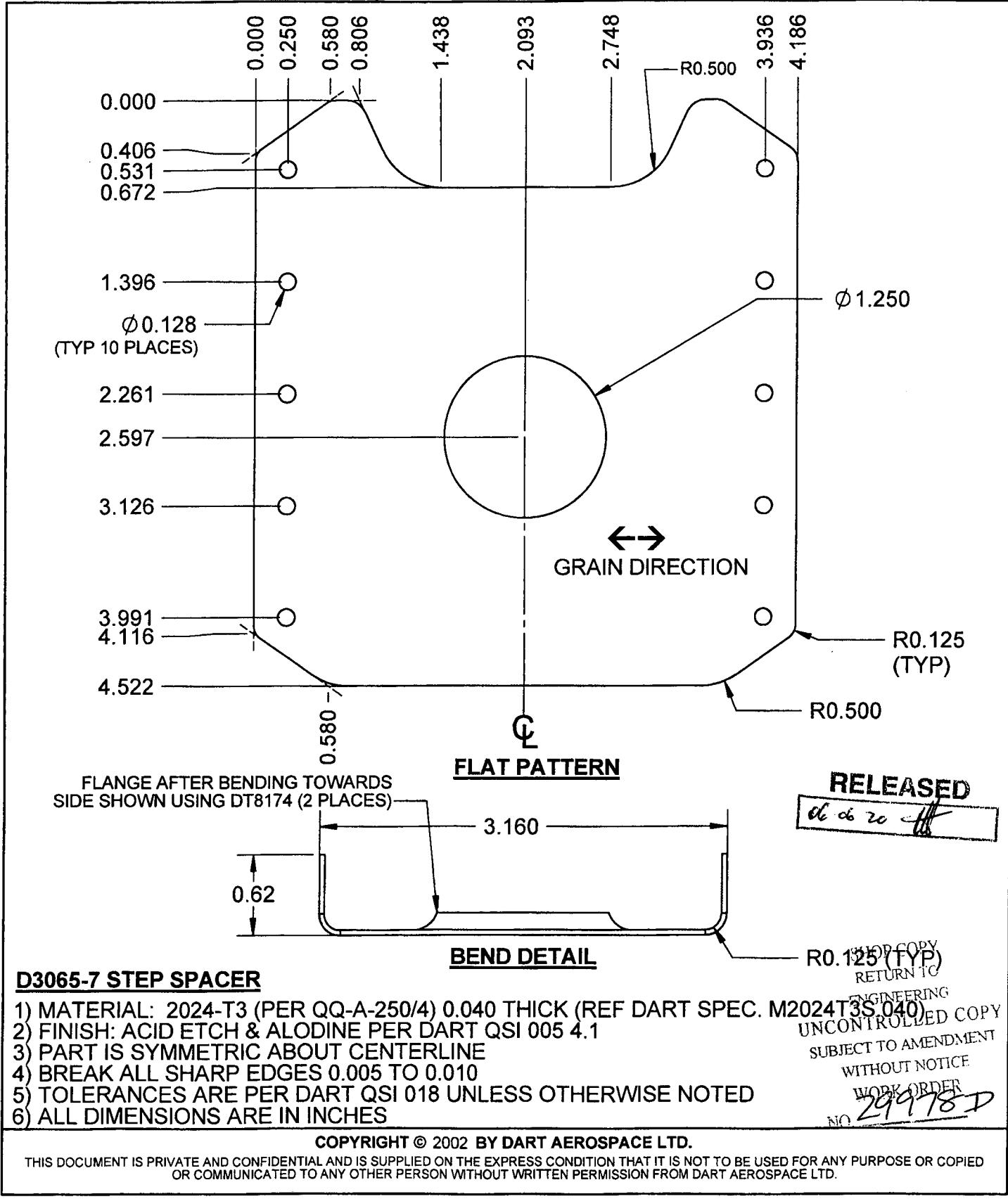
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
06.05.23	D3065	SHEET 4 OF 5
	TITLE	SCALE
	STEP LEG ASSEMBLY	1:3

**RELEASED**  
06.06.02**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



DART AEROSPACE LTD	Work Order:	29978D
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065 Rev: B		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article X Prototype

Measured by:	MM:MM	Audited by:	MM:MM	Prototype Approval:	
Date:	06/12/21	Date:	06/12/22	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	